NCR: Y	es / No				WORK ORDER NON-	COL	VFORM	MANCE / UPE	DATE					
					· · · · · · · · · · · · · · · · · · ·					,	QA Closed:	Da	ite:	
Work Orde	er:				DISPOSITION	_			-	DEF	PARTMENT			
Part N					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining Moforming Marge Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor re/Packaging Supplier		Engineering Quality Other
Root		7		Descr	iption of work order update		nitial	Act	ion		Sign &			
Cause	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process										•				
Training														
Unapproved			<u>l</u>	<u> </u>			TCATE	CORV						
					General	AUL	T CATE	GURY						
Landir	Cracks Crushe Cuffs Heat T Inspec Ripple:	Not Conce	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/t nance iled Calibration sequence	Jnclear 🤾		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Ī	Wave/	Twist in Tu	be		Folio		Outside	Dimensions						<u> </u>

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Will Cri-01-15 1.	37.30 I W										
Item ID: Revision ID:	D3066-1			Accept	*N900	0401	<b>N</b> 0*	Setup	Start Stop	*NS	S1*
Item Name: Start Date: Required Date:	Spacer 3/01/13 4/08/13	Start Qty: 40.00 Req'd Qty: 40.00	*40 *40		Cust Item   Customer:	•				*N.	<b>57</b> "
Reference: Approvals:		lan:	Date:	Tooling: SPC (Y/N):		Pate:			Start Stop	*NF	R1* D2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description	OS1005 4 1	Set Up/ Run Hours	Tool ID	Tool # Pla		t Reje Qty		Reject Number	Insp. Stamp
*130 *130 *HandFinish Hand Finishing		Chemical Conversion Co  Memo	nat per QS1005 4.1	0.00			4	7 1	Al,	13.9	1/2
140 *140* QC		Qe - Inspect Part Finish  Memo	i	0.00			4	D q	f .		19 19 13 04 15
Quality Control		Identify as per dwg & St	ock: Location: 🗚 🗸	003 <sub>0.00</sub>				·			,
*150* Packaging Packaging		Memo	IN STEP CELL***	0.00			40	)	<b>-</b>	lte	13.04.

⁄es	/ No				WORK ORDER NON-O	CON	NFOR	MANCE / UPI	DATE				
										QA Closed:	Date:		
er: _					DISPOSITION	1				EPARTMENT,		Engineering	
Part No.  NCR No.  Root De					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Prod. Eng. Coor.  Rec/Store/Packaging Supplier		
					•	1				Sign &			
	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
												,	
					· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY			<u></u>		
	Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. It In Strip in Bend Vaves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Hardwa Inspect Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete tions Incomplete/U enance eled d Calibration	Jnclear	Part Incorre Part Lost/M Part Moved Positioned \	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	er:	ng Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Date Step  Date Step	Date Step Qty  Date Step Qty  Date Step Cty  Date Step Cty  Cty  Date Step Cty  D	Process of the state of the sta	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Bending Gear General  Centre Not Concentric to O/S Cracks Broken/Damaged  Crushed/Crimped Burrs  Cuffs Contamination  Cuffs Contamination  Cuffs Contamination  Cuffs Countersink  Inspection Strip in Tube  Ripples in Bend Drill Holes  Drawing  Drawing	Part   Disposition	PAULT CATE  Gear  Bending Centre Not Concentric to O/S Cracks Cracks Cracks Cracks Cracks Crushed/Crimped Cutffs Heat Treat Inspection Strip in Tube Rework Scrap Use-as-is Work Order update Or Non-conformance  FAULT CATE  General Bend Bend Bend Bend Bend Bend Bend Bend	Primary and the property of th	Principle of the properties of	DISPOSITION  Rework   Scrap   Use-as-is   Uarge Fab   Composite   Proposition   Composite   Proposition   Proposit	DISPOSITION   Rework   Skid-tube   Crosstube   Prod. Eng. Coor.	

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

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Work Orde		3003			*980	003*							Page 3	1
Item ID: Revision ID: Item Name:	D3066-1 Spacer				Accept	*N900	<b>040</b>	100	)*	Setup !	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	3/01/13 4/08/13	Start Qty: 40.00 Req'd Qty: 40.00	.*	*40* *40*		Cust Item I Customer:	D:	·. ·		÷			1	
Approvals:	Process Pl	an:	Date:_ Date:_		Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*	
Sequence ID/ Work Center II	)	Operation Description OC21- Final Inspection -	Work Order	r Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		eject lumber	Insp. Stamp	-

0.00

Memo

\*160\*

Quality Control

13/4/16 D

Date: \_\_\_\_ **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Small Fab Prod. Eng. Coor. Quality Scrap Machining Part No. Finishing Rec/Store/Packaging Other Use-as-is Thermoforming Supplier Large Fab Work Order Update Composite NCR No. Sign & Description of work order update Initial Action Root Verification or Non-conformance Chief Eng Description Date QC inspector Date Step Qtv Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY** General **Landing Gear** Pressure/Forced Grain Ovalized Bend Bending BOM/Route Temperature/Cure Hardware Over/Under tolerance Centre Not Concentric to O/S Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped. Burrs Part Moved Contamination Maintenance Cuffs Positioned Wrong Mislabeled Countersink Heat Treat Other Misread Power Loss/Surge Cut Too Short Inspection Strip in Tube Drill Holes Offset Ripples in Bend

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Turning Sequence

Wave/Twist in Tube

**Torque Waves in Extrusion** 

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-01-13 1:57:35 PM

Work Order ID:

98003

Parent Item:

D3066-1

Parent Item Name:

Spacer

**Start Date: 3/01/13** 

Required Date: 4/08/13

**Start Qty: 40.00** 

Required Qty: 40.00

**Comments:** 

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	1.0000	0.0945	3.978948	nΛ	13.03	06
				<b>Location</b>		Loc Qty	Lo	c Code					
			•	MAT021		1.000032							
			B#i	24786 117 124		0.497264 0.502768							

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Water Jet Engineering Rework Skid-tube Crosstube Prod. Eng. Coor. Quality Machining Small Fab Scrap Part No. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Composite Supplier Work Order Update Large Fab NCR No. Description of work order update Action Sign & Initial Root Chief Eng Description Date Verification QC Inspector or Non-conformance Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY** 

	 1	_			$\overline{}$			
	Heat Treat		Countersink	Mislabeled	Ш	Positioned Wrong		
	Inspection Strip in Tube		Cut Too Short	Misread	Ш	Power Loss/Surge	Other	_
	Ripples in Bend		Drill Holes	Offset				
į	Torque Waves in Extrusion		Drawing	Out of Calibration				_
	Turning Sequence		Finish	Out of Sequence			 	
	Wave/Twist in Tube		Folio	Outside Dimensions				

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

**Landing Gear** 

Bending

Cracks

Cuffs

Crushed/Crimped.

Centre Not Concentric to O/S

DART AEROSPACE LTD	Work Order:	98003
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.12.8	/		VerN	MN-01
0.708	+/-0.010	0.703	~		VerN	// 1
0.354	+/0.010	0.35 2			vern	//
0.354	+/0.010	0.352			VerN	// 5
2.250 (Pitch)	+/-0.005	2.251	V	····	vern	" >
16.450	+/0.010	16.450	V		EMD MI	- MM-02
0.080	+/-0.010	0.078			Verw	MN-02 MN-01
				-		
		·				
		-				

Measured by: Audited by: Prototype Approval: N/A

Date: 13 · 03 · 06

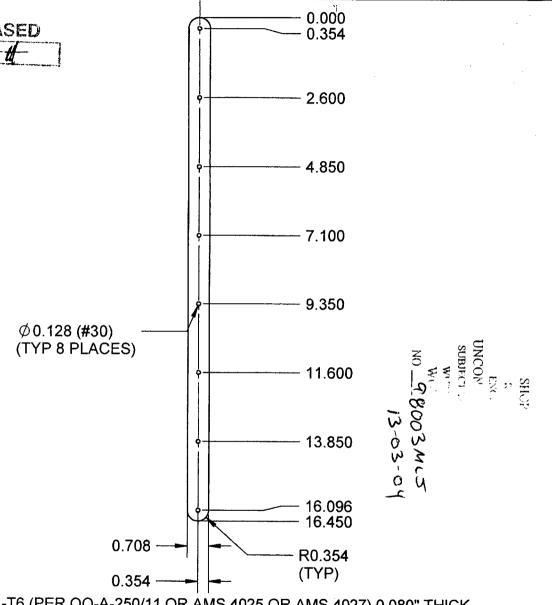
Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	1
B	06.06.23	Dwg Rev. changed	KJ/JLM J	ad
			· · · · · · · · · · · · · · · · · · ·	<del>- 7~//</del>



DESIGN DRAWN BY DART AEROSPACE LTD CB APPROVED HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 02.09.11 Α **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

RELEASED de de 20 -#



1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

**D3066-1 SPACER** 

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC. M5052H32S.080) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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